Dart Aerospace Ltd.

Date: Friday, 12/21/2007 7:27:22 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 36511		
Estimate Number	: 10954		
P.O. Number	: N/A	Part Number	: D2562013
This Issue	: 12/21/2007 S.O. No. : N/A	Drawing Number	: D2562 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 36365	Material	: N/A
Written By	:	Due Date	: 1/20/2008 Qty: 10 Um: Each
Checked & Approved By	: 071221		
Comment	: Est A 05.05.18 New Issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
	Comment: Qty.: 2.4062 f(s)/Unit Total : 24.0618 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch M106593 (4) M106593 (2) SB 08/01/07 (10)	
2.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Punch to length as per Dwg D2562 SB 08/01/07 10	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2- Deburr 08/01/08 (10)	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP 08/01/08 (10)	
5.0	POWDER COATING	POWDER COATING
	M106379 (10X)	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 08/01/11	

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: LD Date: 28/01/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36511 **Part Number:** D2562013

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	BR 08-01-12 (10)
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST270	8/01/14 (10)
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08/01/15 (10)

Job Completion

08/01/15

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

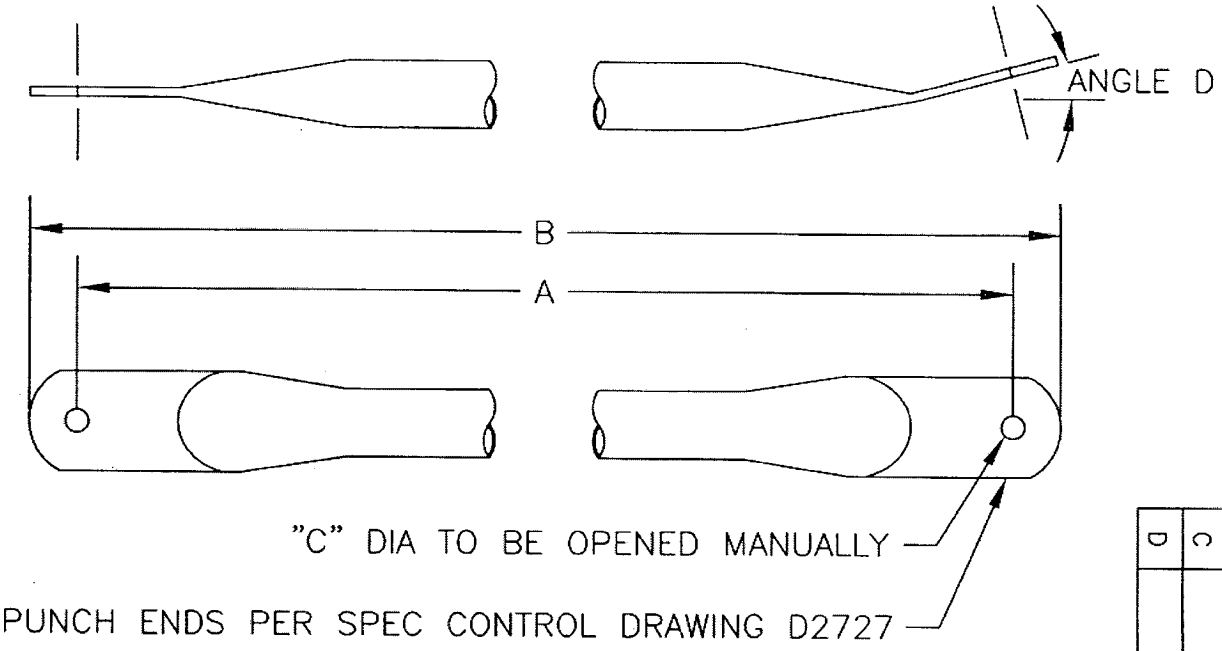
QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2562 — REV. D
DATE 05.05.18		TITLE STRUT — SHEET 1 OF 1 — SCALE 1:2

A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
D	05.05.18	ADD -007/-011/-013; UPDATE -005



RELEASED 05.05.27

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	–	10
D2562-003	20.37	21.17	–	18
D2562-005	29.00	29.80	–	30
D2562-007	19.22	20.02	–	0
D2562-011	25.79	26.59	–	16
D2562-013	26.63	27.43	–	24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No 36511

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES